

Work Order ID 164925

Wednesday, August 09, 2017 3:17:23 PM

164925

Page 2

Item ID: 647.7914 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 8/10/2017 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 8/18/2017 Req'd Qty: 15.00 ***15*** Customer:
Reference: AOG RUSH

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>15</u>			DAS 38 9-89 AUG 10 2017
140 *140* Brake NC Brake NC	Form as per dwg Memo	0.00 1.67				<u>12</u>	<u>3</u>	AUG 11 2017	DAS 19 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>12</u>			DAS 38 9-89 AUG 11 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
SprayPaint	Memo	0.00							
Spray Painting	PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)								
	CARDINAL 4860-50 PRIMER BATCH: _____								
200	QC14- Inspect Spray Paint	0.00							
200									
QC	Memo	0.00							
Quality Control									

P.T.O.
last page

CZ 17/08/18

N/A done@ ATG

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

AUG 24 2017

Picklist Print

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Page 1

Work Order ID: 164925

164925

Parent Item: 647.7914

647 7914

Parent Item Name: Bracket

Start Date: 8/10/2017

Required Date: 8/18/2017

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.090		Purchased		No		110	sf	45.5200	0.084	1.326316			DAS
M2024T3S 090									**			17/08/10	40
2024-T3 .090 sheet													9-89

Location

Loc Qty

Loc Code

MAT021

45.52

123287

12.82

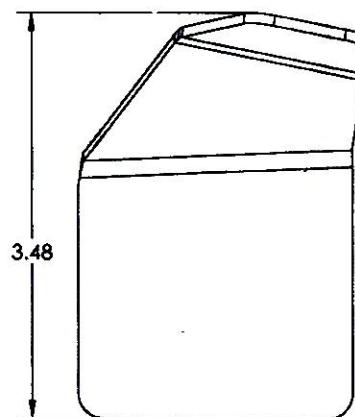
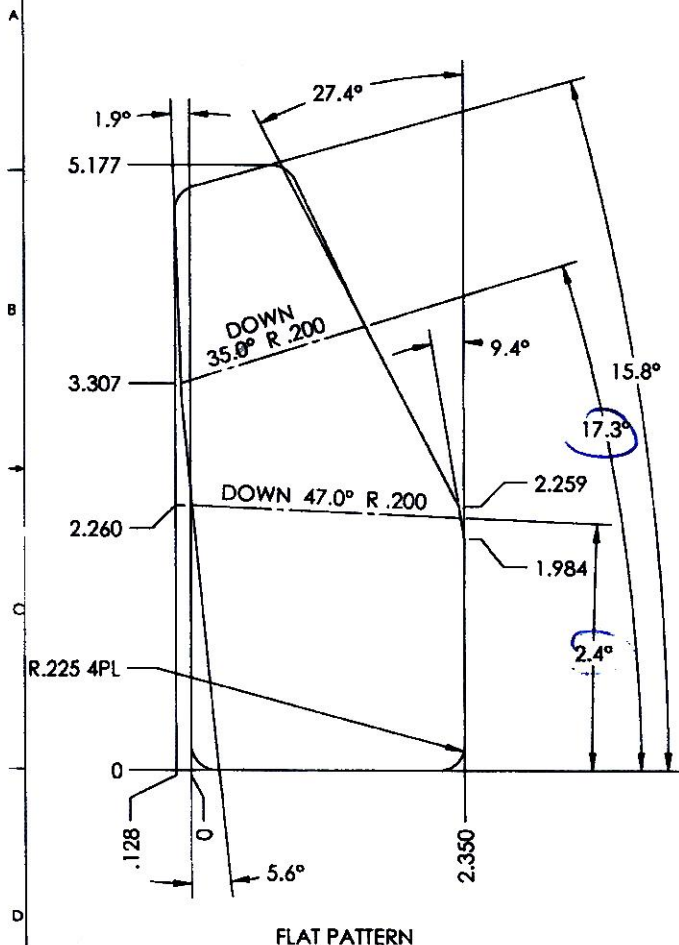
m130387

32.7

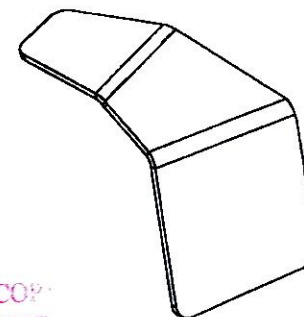
1.4

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REV	DESCRIPTION	DATE	APPROVED

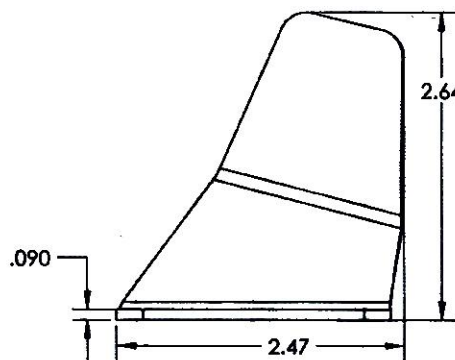


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164925MS

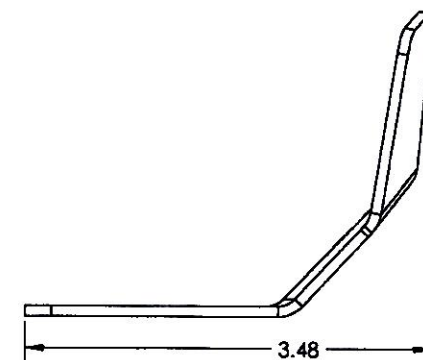


647.7914
647.7915 OPPOSITE

AUG 09 2017



647.7914 SHOWN
647.7915 OPPOSITE



ORIGINAL DATE APPROVAL DATE E. ANDERSON P. BRAVO REVIEWED APPROVAL DATE CORRECTION NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS AND ANGLES ± .1°		REV. NO. 647.7900	REV. N/C
SCALE NONE		SHEET 4 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37419**

Purchase Order Date 8/14/2017

PO Print Date 8/15/2017

Page Number 1 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	164925	647.7914 Bracket	8/17/2017 No 8/17/2017		12.00 ✓ CXL17108118	\$0.00	\$0.00
As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P-23377J TypeI Class N As Per Dwg. 647.7900 Rev. N/C RUSH!!!!							
Line Total:							\$0.00
2	164443	646.3312 Center Plate	8/21/2017 No 8/21/2017		12.00	\$0.00	\$0.00
As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-PRF-23377 TypeI Class N AS PER DWG 646.3300 REV.A							
Line Total:							\$0.00

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

8/15/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913716

Date: 18-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 647.7914 ✓ Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21578	Rev: N/C	
	PO: PO37419	Line: 1	C217108118
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>18/8/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>164925</u> Part No. <u>647-7914</u> NCR No. <u>NCR 17-6588</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>17-08-18</u>		Step #: <u>140</u>		QTY Effective: <u>15</u> <u>12</u>			MRB (QSI042) Approval DAS 9 17-08-18 9-89		
Description Work Order Deviation				Disposition				Completed By DAS 38 AUG 17 2017 9-89 Lead hand / Supervisor Approval Verification DAS 38 AUG 17 2017 9-89 QC / QA Coordinator Approval DAS 9 17-08-18 9-89	
Material cracks while bending found ^{out} after priming hard to see at inspections R.C. Material				Scrap / destroy no replace					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☒ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☒ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☒ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐				OTHER :	

Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Tuesday, August 22, 2017

Details			
Raised Date 8/21/2017	Status Open	Owner Menard, Jean-Luc	Number NCR17-6588
Target Date 9/8/2017	Standard ISO 9001:2008 / AS9100\7.0 Product Realization\7.5 Product And Service Provision\7.5.1 Control of production and service provision\7.5.1.1 Production Process Verification		Severity MINOR
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Manufacturing		Fault Category General\Instructions Incomplete/Unclear
Details			
Found on W/O 164925 647.7914 that after outsource processing (Anodizing & Priming) that parts were cracked in the bend areas			
Keywords		Product 647.7914	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 8/31/2017	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M		
perform root cause to why parts failed			

Corrective Action			
Target Date 9/8/2017	Owner Menard, Jean-Luc	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
2	Duval, Patrick	8/25/2017	
Scrap non-conforming parts		completed	
3	Boucher, Sylvie	8/25/2017	
Re make parts on new work order			

Implementing Corrective Action			
Target Date	Owner	Closed Date	Closed By
9/8/2017	Menard, Jean-Luc		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
4	Menard, Jean-Luc	9/8/2017	
Review Root cause & implement actions needed to ensure parts are not manufactured incorrectly			

Verification & Review			
Target Date	Owner	Closed Date	Closed By
9/8/2017	Downing, Eric M		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	